

Date: Thursday, 5/4/2006 11:14:18 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 26957  
Estimate Number : 12177  
P.O. Number : *NIA*  
This Issue : 5/4/2006 S.O. No. : *NIA*  
Prsht Rev. : NC  
First Issue : *NIA* Type : SMALL /MED FAB  
Previous Run : 26617  
Written By : *[Signature]*  
Checked & Approved By : *[Signature] 06.05.05*  
Comment : Est Rev: A New Issue 06-02-03 JLM

Drawing Name : BLOWER MOTOR ADAPTER  
Part Number : D3476041  
Drawing Number : D3476 REV A  
Project Number : N/A  
Drawing Revision : A  
Material : *NIA*  
Due Date : 5/28/2006 Qty: *2* Um: 8 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3476043 blower motor adapter weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3476-043	ADAPTER WELDMENT	<i>B26994-2</i>

2.0 D34765 spacer ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3476-5	Ring	<i>B26619</i>

3.0 AN34A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-4A	Bolt	<i>M18369</i>

4.0 AN96010 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	<i>M5519</i>

*2B 06/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 28 Date: 06/08/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 5/4/2006 11:14:18 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 26957

Part Number: D3476041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3476

SB 06/08/09 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-14 ①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: C.A.

SB 06/08/21 ①

8.0

DC

DOCUMENT CONTROL

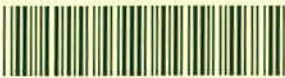


Comment: DOCUMENT CONTROL

Inspection Level 21

06-08-24

Job Completion



06-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

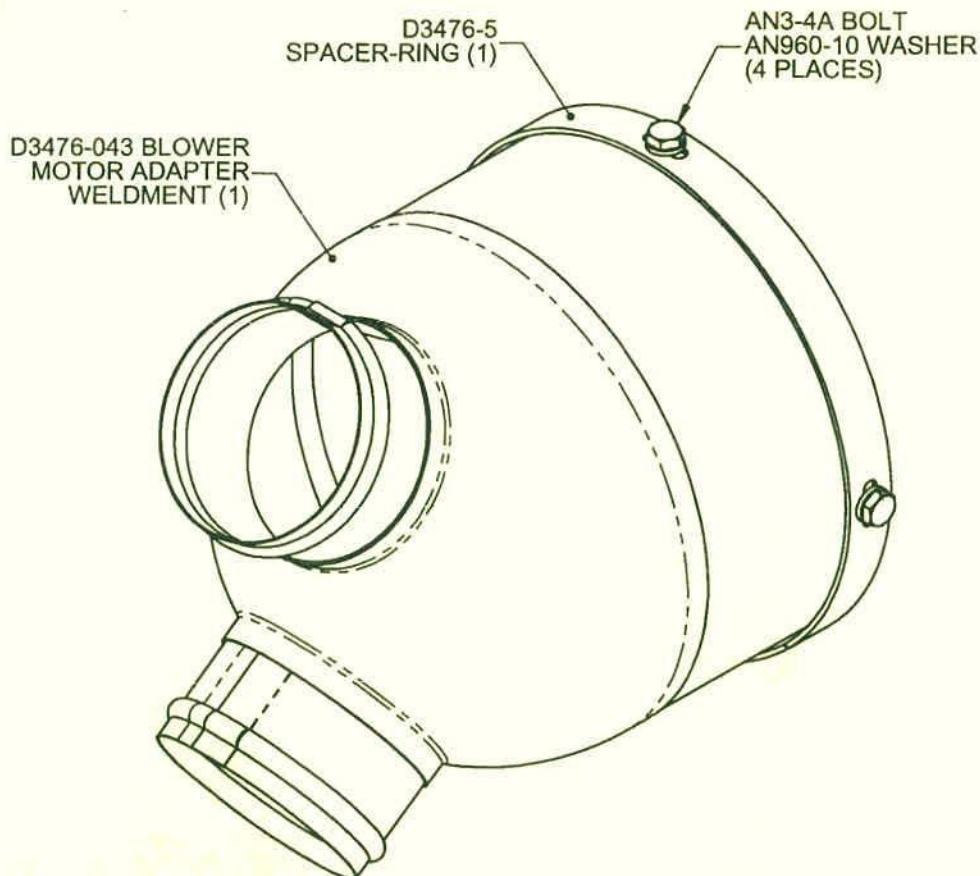
NOTE: Date & initial all entries





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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 1 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b> SCALE 1:2	
A	06.01.27	NEW ISSUE	

*[Signature]* 06.04.03



### **D3476-041 BLOWER MOTOR ADAPTER**

1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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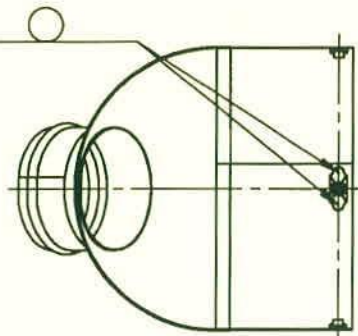




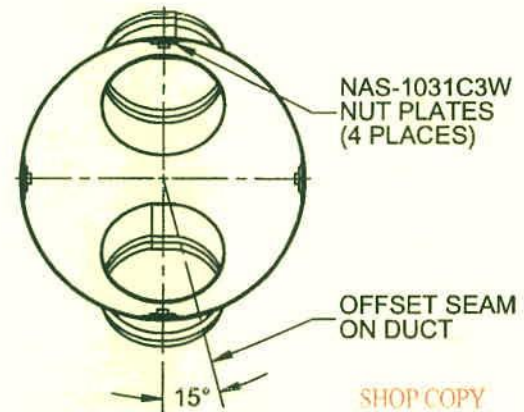
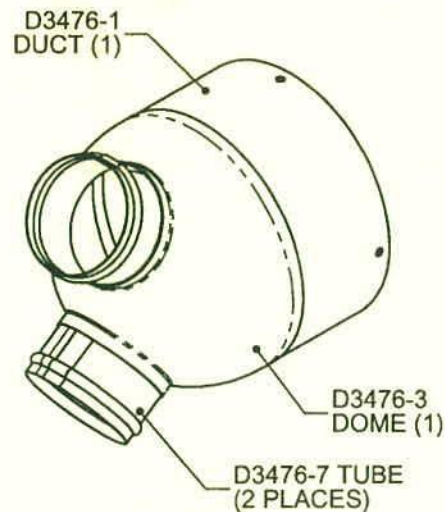
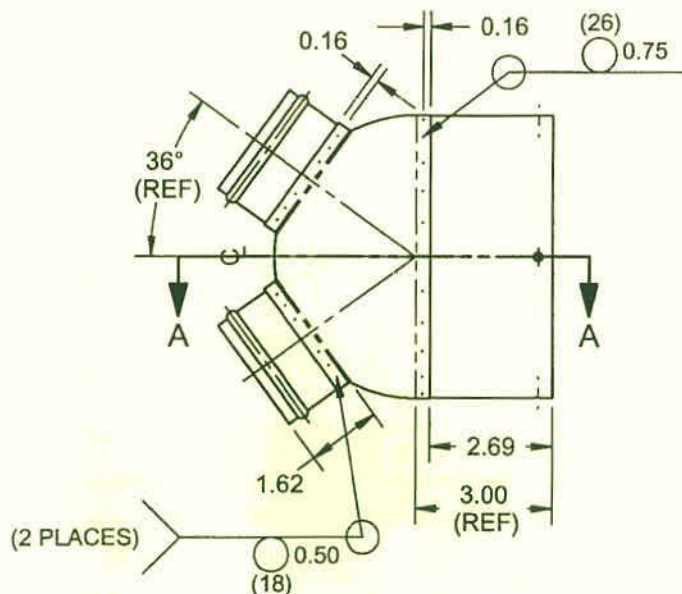
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:4

LOCATE AND  
SPOT WELD  
NUT PLATES  
(4 PLACES)



**SECTION A-A**



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**D3476-043 BLOWER MOTOR  
ADAPTER WELDMENT**

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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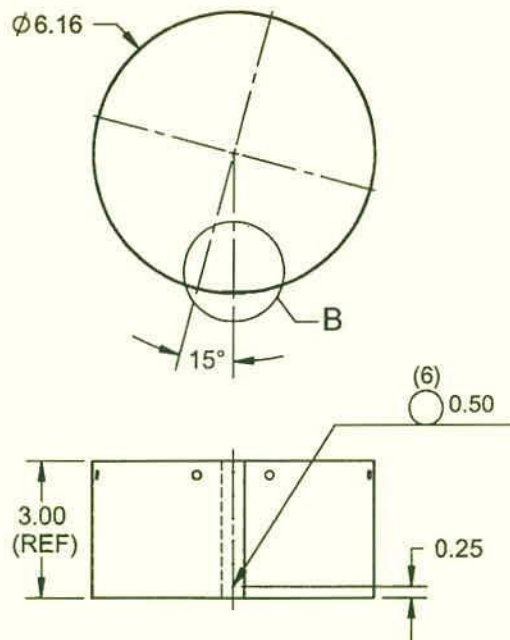




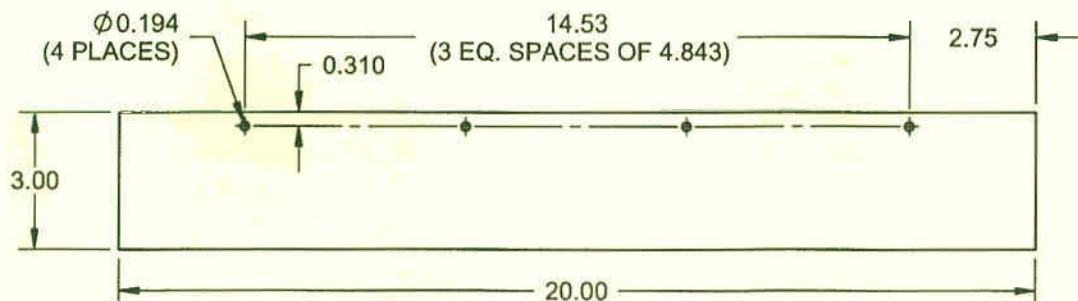
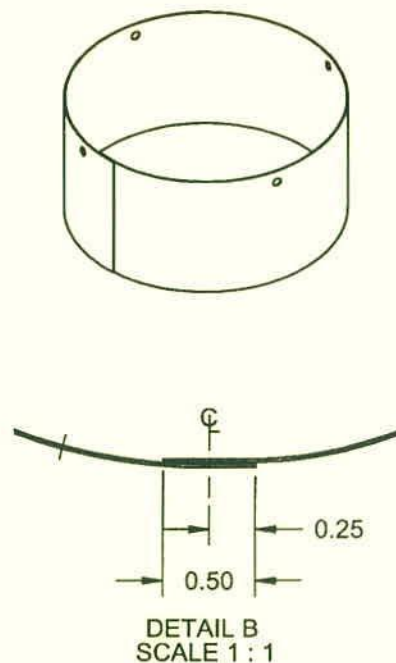


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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

*[Signature]* 06.01.03



**D3476-1 DUCT**



**D3476-1F DUCT FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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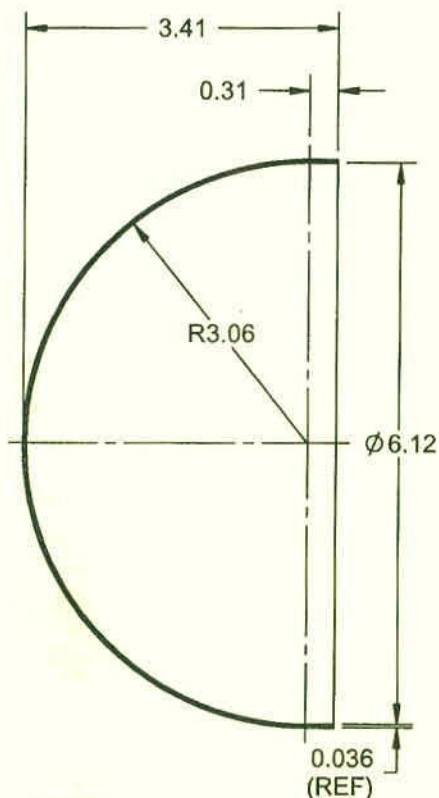
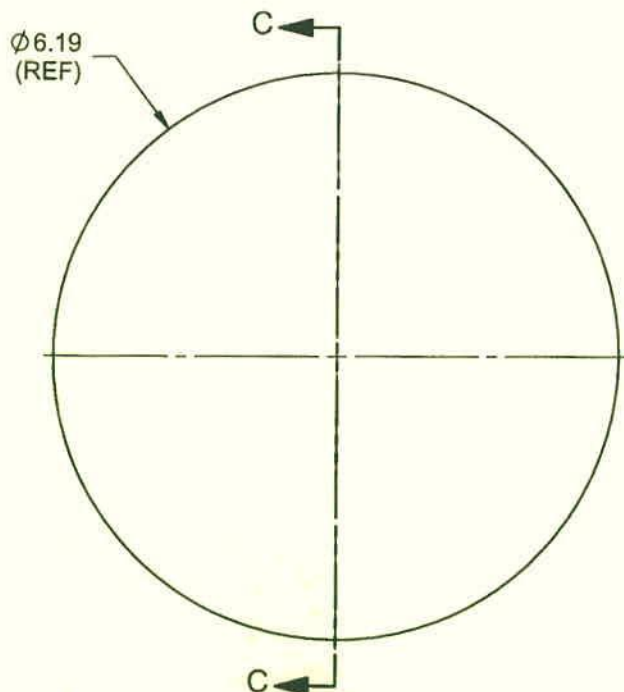
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

RELEASED

06.04.03 *[Signature]***SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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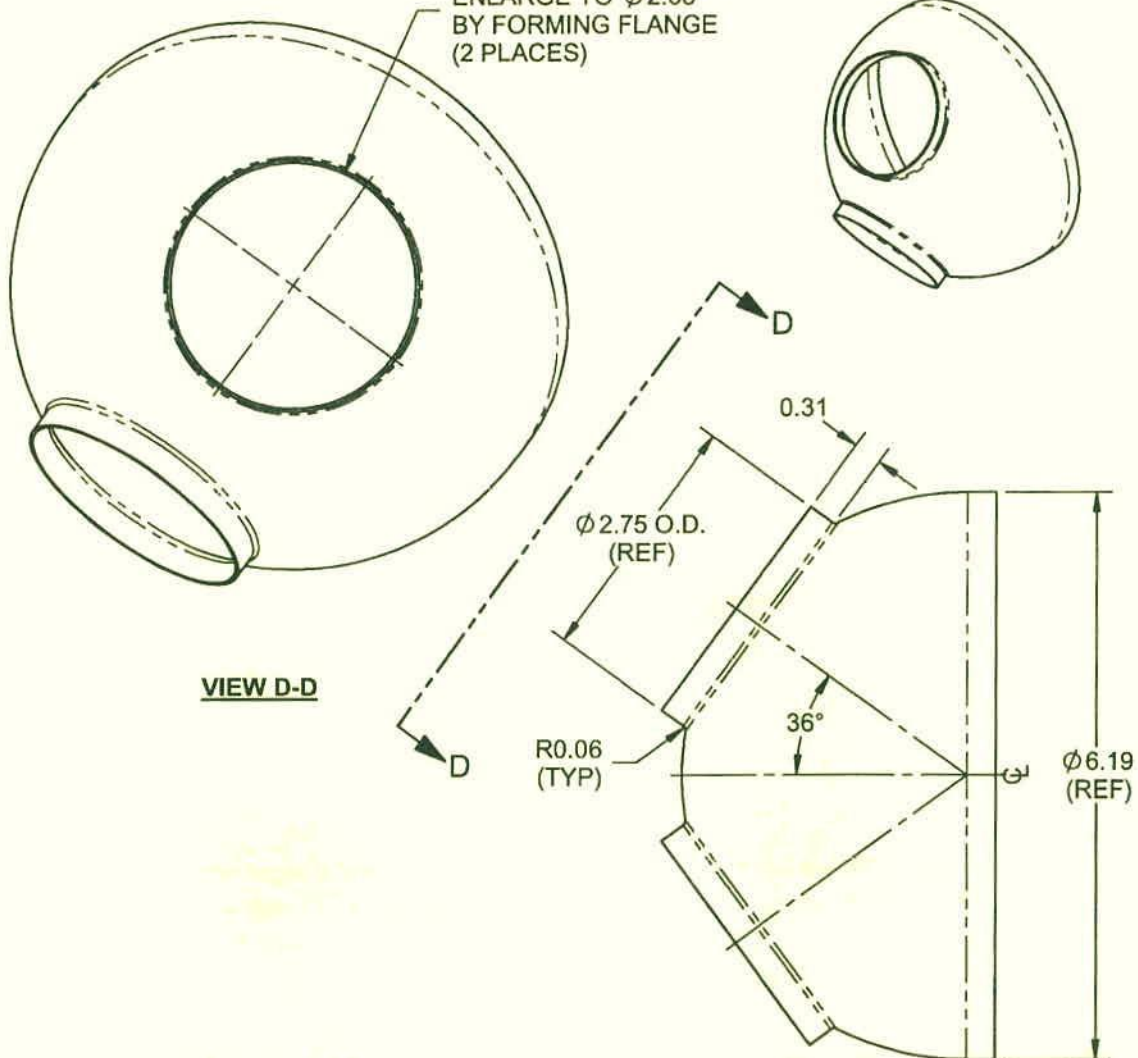


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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

# 06.04.03

CUT  $\phi 2.25$  HOLE,  
ENLARGE TO  $\phi 2.68$   
BY FORMING FLANGE  
(2 PLACES)

**VIEW D-D****D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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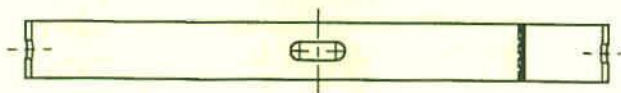
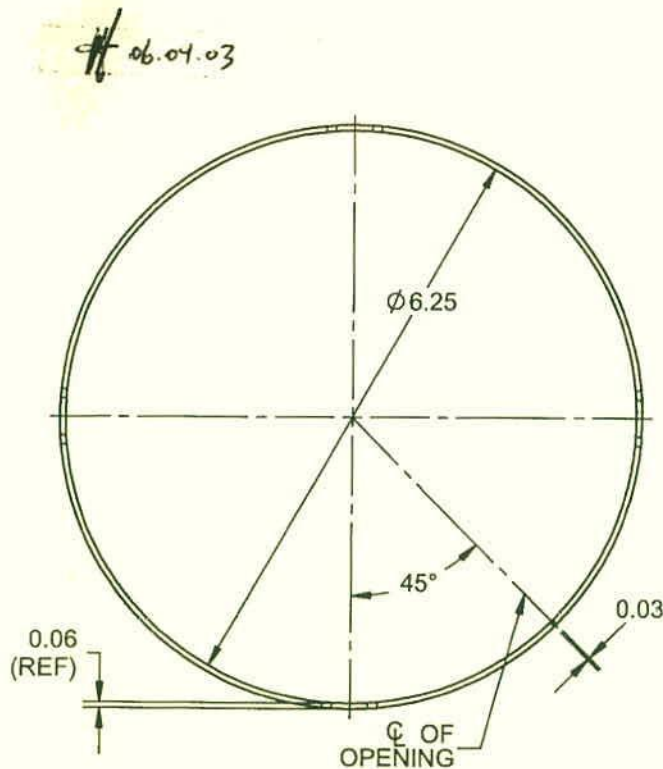
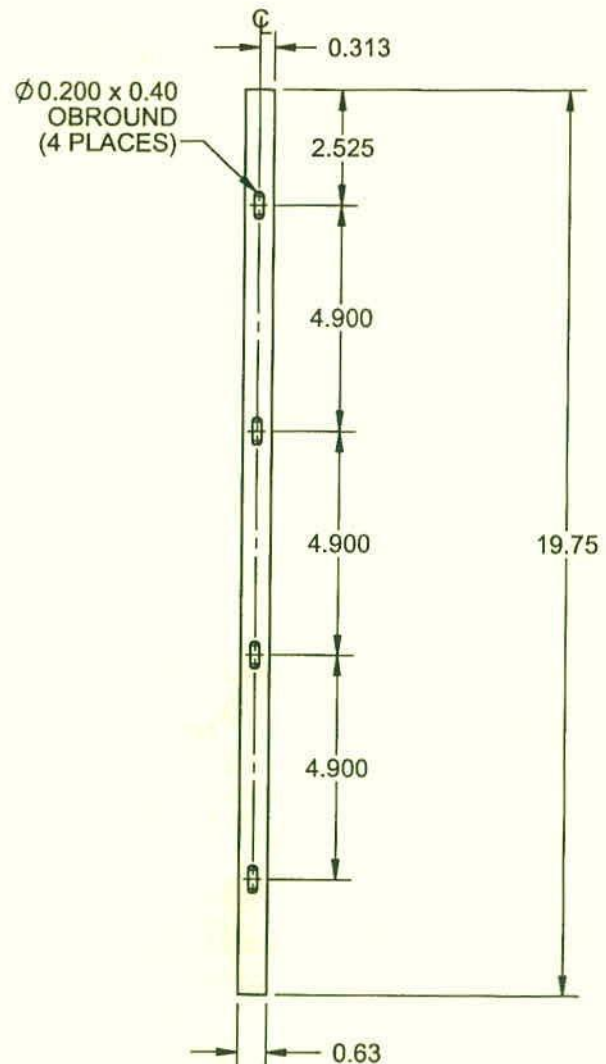
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

**D3476-5 SPACER-RING****D3476-5F SPACER-RING  
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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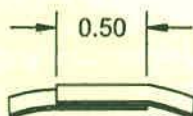
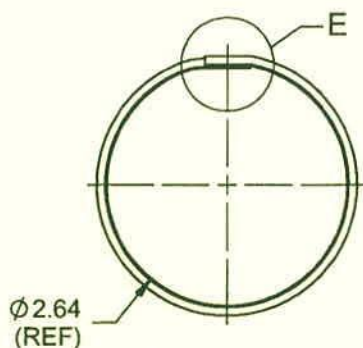
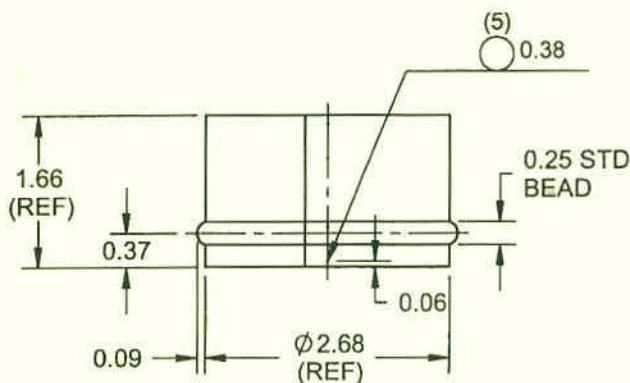
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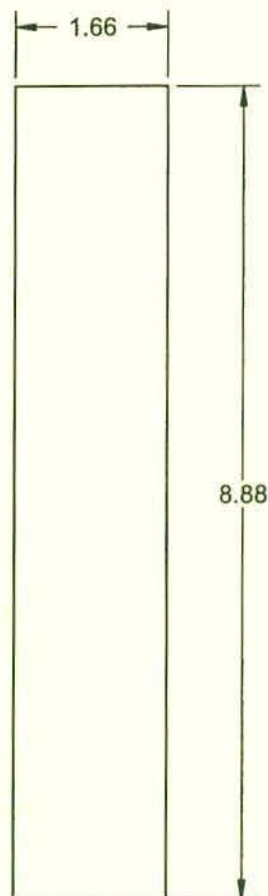
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

*[Signature]* 06.04.03

DETAIL E  
SCALE 1 : 1

### D3476-7 TUBE



### D3476-7 TUBE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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